

132293

Wednesday, May 06, 2015 10:20:35 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

8

Start Date: 5/06/15 **Start Qty:** ~~7.00~~

7

Cust Item ID:

Required Date: 5/22/15 **Req'd Qty:** 7.00

7

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date: 5.5.6

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Draw Nbr	Revision Nbr	
647.1700	C2	

0.00

105

Small Fab

Small Fab

Memo

PULL FROM STOCK

647.1711 X7

91799 X6

93413 ~~XZ~~

REDRILL HOLES TO NEW SIZE AT .257

AS PER ECN 15-555

115

0.00

115

HandFinish

Hand Finishing

Memo

TOUCH PAINT IN HOLES THAT WERE REDRILLED

MAY 06 2015

**DAS
41
9-89**

for
C.R

15-5-7

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Page 2

MCS MAY 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Page 1

Wednesday, May 06, 2015 10:20:40 AM

Work Order ID: 132293

132293

Parent Item: 647.1711

647 1711

Parent Item Name: Plate

Start Date: 5/06/15

Required Date: 5/22/15

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 12.10.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1711		Manufactured	No				Each	0.0000		7			

647 1711

Plate

Q1799 X6

Q4413 X2

DIS-S-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

04702

SHEET 1 C 2

DWG NO. 647.1700

REV: C

PREPARED BY:

J. BECKER

DATE: 03/18/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE

R-REVISE D-DELETE

REASON: REVISED HOLE DIMENSION. ADDED DELTA NOTES 7-10.

ECR #:

ACTIONS:

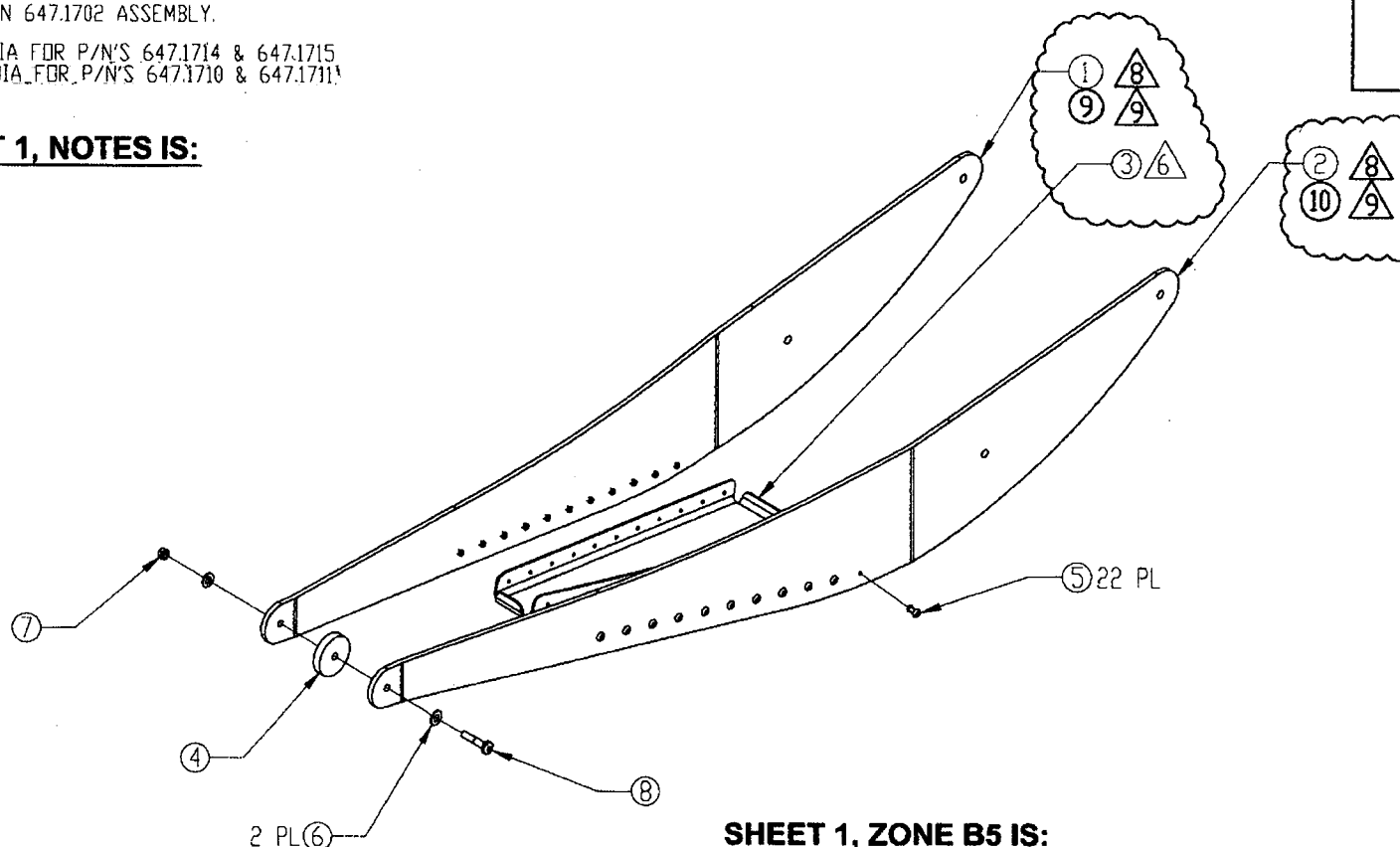
7 WITH EXCEPTION OF HOLE DIMENSION, ALL DIMENSIONS SAME AS P/N 647.1710 AND P/N 647.1711. RESPECTIVELY.

8 FOR P/N 647.1701 ASSEMBLY.

9 FOR P/N 647.1702 ASSEMBLY.

10 323" DIA FOR P/N'S 647.1714 & 647.1715
257" DIA FOR P/N'S 647.1710 & 647.1711

SHEET 1, NOTES IS:



SHEET 1, ZONE B5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUC

☐ ICA ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

04702

SHEET 1 C 2

DWG NO. 647.1700

REV: C

PREPARED
BY:

J. BECKER

DATE: 03/18/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):

A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED HOLE DIMENSION. ADDED DELTA NOTES 7-10.

ECR #:

ACTIONS:

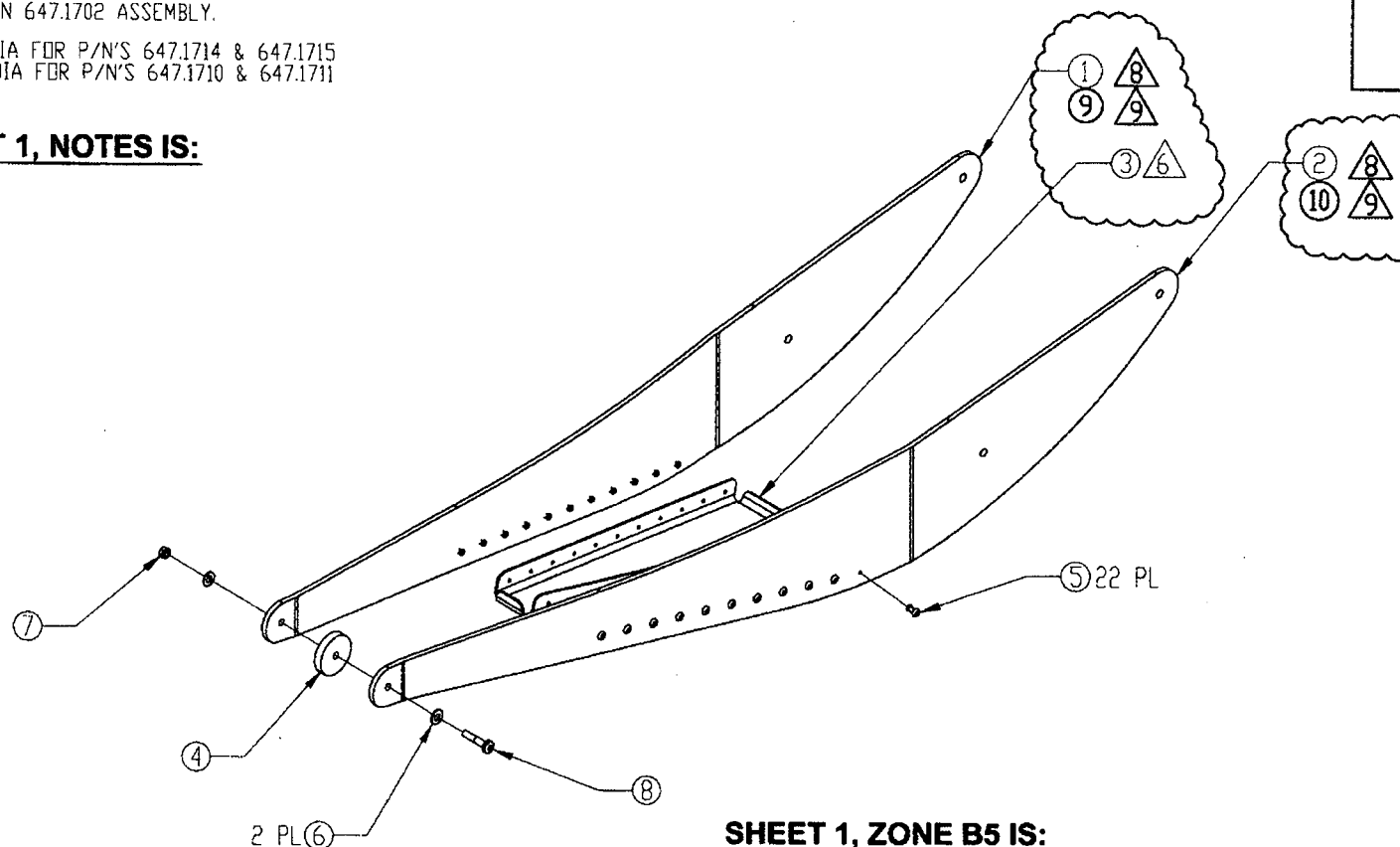
△ 7 WITH EXCEPTION OF HOLE DIMENSION, ALL DIMENSIONS SAME AS
P/N 647.1710 AND P/N 647.1711. RESPECTIVELY.

△ 8 FOR P/N 647.1701 ASSEMBLY.

△ 9 FOR P/N 647.1702 ASSEMBLY.

△ 10 .323" DIA FOR P/N'S 647.1714 & 647.1715
.257" DIA FOR P/N'S 647.1710 & 647.1711

SHEET 1, NOTES IS:



SHEET 1, ZONE B5 IS:

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRU

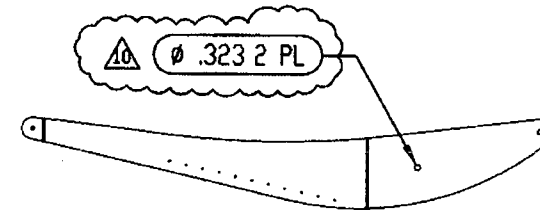
☐ ICA ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

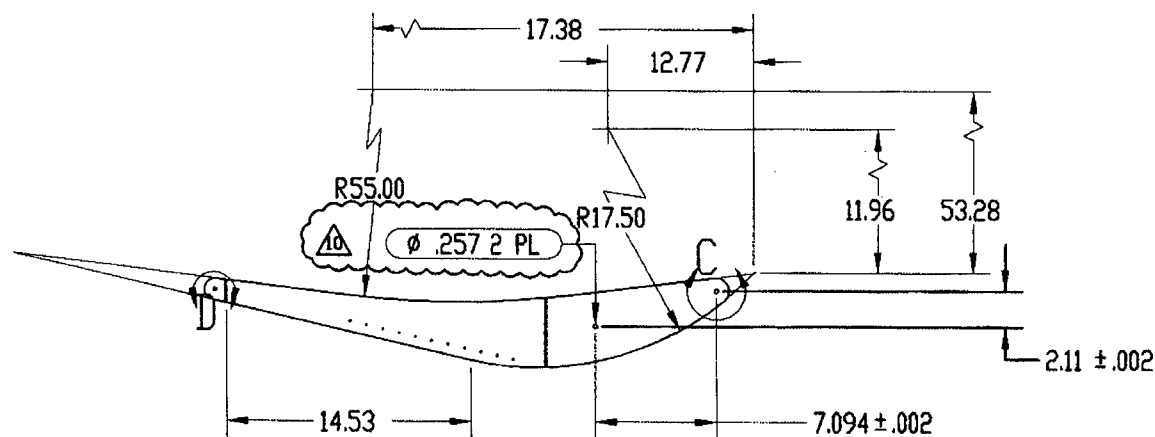
DER REVIEW REQUIRED

☐ YES ☒ NO



647.1714 SHOWN
647.1715 OPPOSITE 

SHEET 3, ZONE C8 IS:



SHEET 3, ZONE D4 IS:

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NC 04679

SHEET 1 OF 1

DWG NO. 647.1700

REV: C

PREPARED BY: J. BECKER

DATE: 09/10/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: SKID DEFLECTOR ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED BOM QUANTITY FOR 647.1702.

6	R	601.1607	2	2	WASHER	NAS1149F0332P	
5	R	601.1915	22	22	RIVET	CR3213-4-4	
F/N	TC	PART NUMBER	.1702	.1701	DESCRIPTION	MATERIAL	SPECIFICATION
		QTY					
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
☐ MDL ☐ INSTALL INSTRU ☐ ICA ☒ BOM						☐ MAJOR ☒ MINOR	☐ YES ☒ NO

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NOTES:

1 MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12

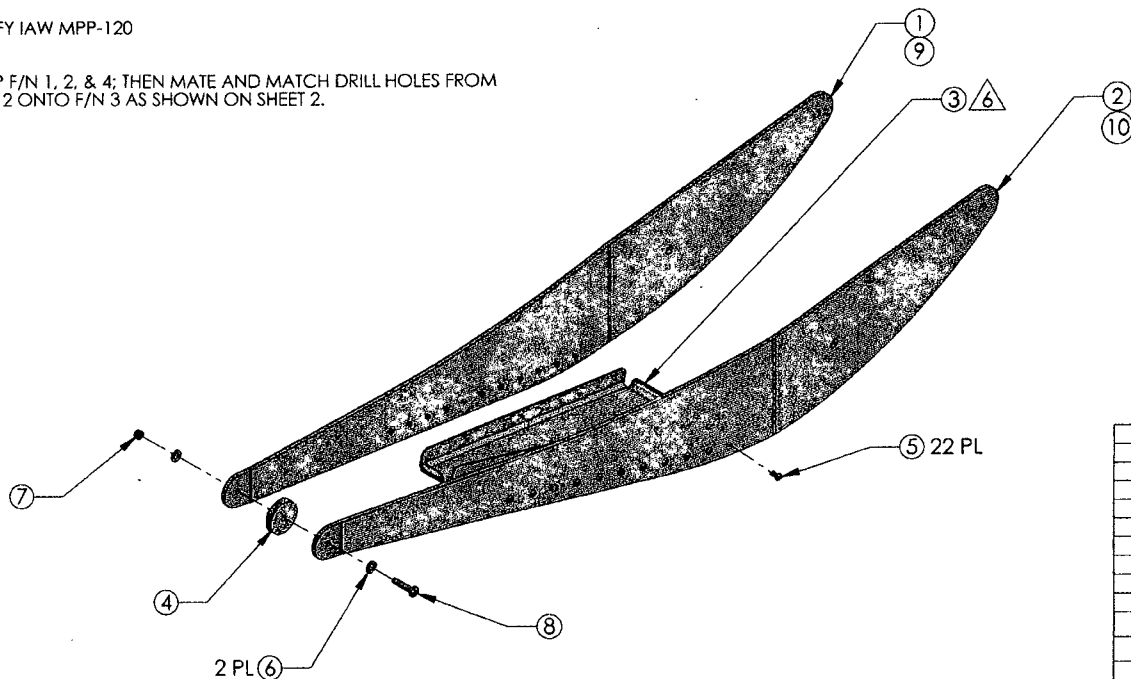
2 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11

3 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER, COLOR BLUE; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX

4 DEBURR AND BREAK ALL SHARP EDGES

5 IDENTIFY IAW MPP-120

6 CLAMP F/N 1, 2, & 4; THEN MATE AND MATCH DRILL HOLES FROM F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2.



UNINCORPORATED ECN(s)

04079, 04702

REV.	DESCRIPTION	DATE	APPROVED
N/C	LAST PROTOTYPE REVISION: PR2		N/C
N/C	INITIAL RELEASE	08/05/09	P. BRAVO
A	INCORPORATED ECN'S 02937 & 03921	06/07/13	P. BRAVO
B	INCORPORATED ECN 03970	07/03/13	P. BRAVO
C	INCORPORATED ECN 04058	08/14/13	P. BRAVO

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
1		10	647.1715 PLATE	△	△
1		9	647.1714 PLATE	△	△
1	1	8	601.1622 SCREW	MS27039-1-14	
1	1	7	601.2943 LOCKNUT	MS21042-3	
1	2	6	601.1607 WASHER	NAS1149FQ332P	
1	22	5	601.1915 RIVET	CR3213-4-4	
1	1	4	647.1713 SPACER	△	△
1	1	3	647.1712 GUSSET	△	△
1	1	2	647.1711 PLATE	△	△
1	1	1	647.1710 PLATE	△	△
X			647.1702 SKID DEFLECTOR ASSY		
X			647.1701 SKID DEFLECTOR ASSY		
.1702	.1701				

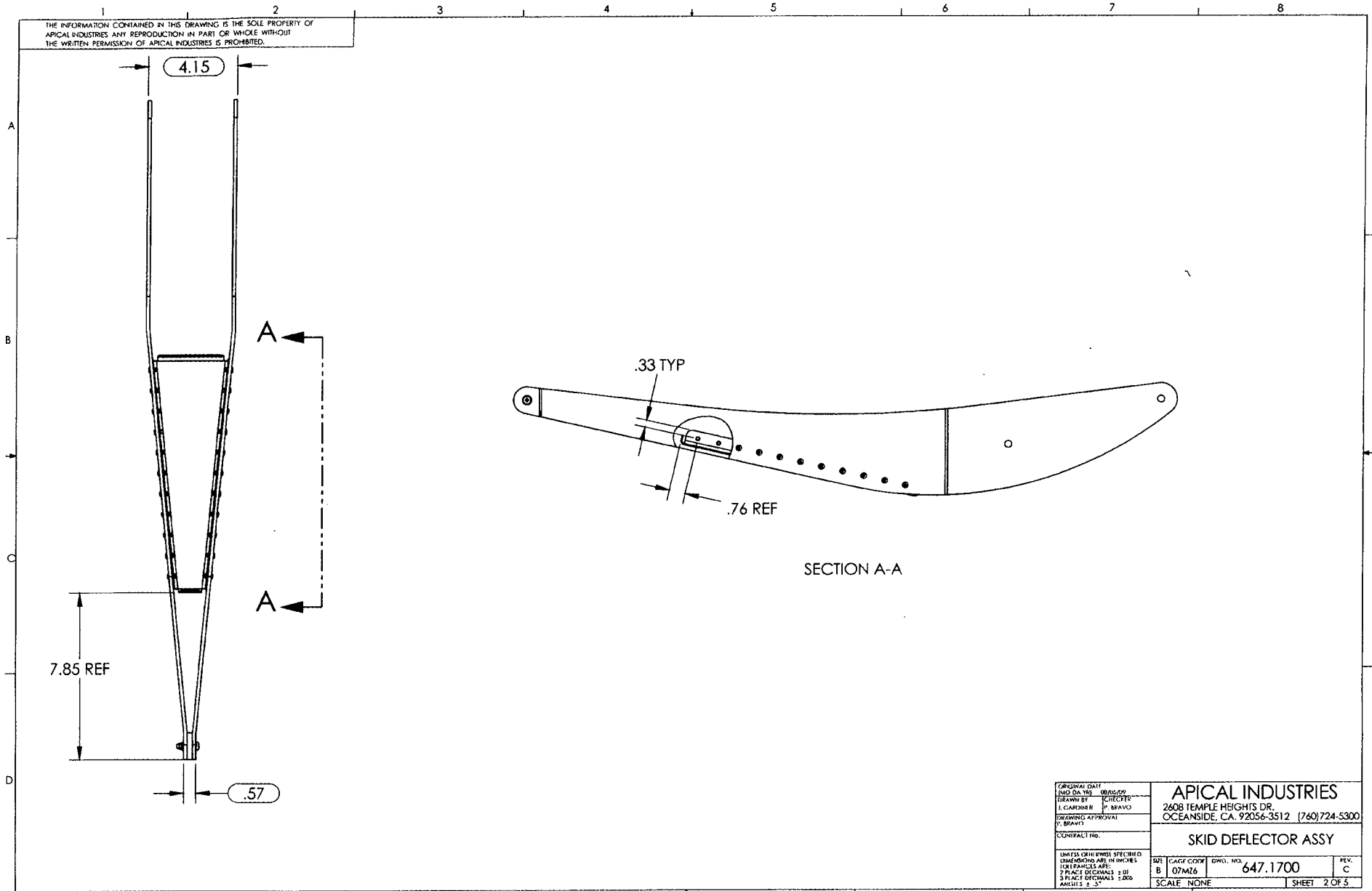
QTY	DESCRIPTION	DATE	APPROVED
647.1300	SKID DEFLECTOR ASSY		

ORIGINAL DATE	08/05/09
DESIGNED BY	J. GARDNER
CHECKED BY	P. BRAVO
APPROVED BY	
CONTRACTING	

UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ARE:	
2 PLACE DECIMALS ±.01	
3 PLACE DECIMALS ±.005	
ANGLES ±.5°	

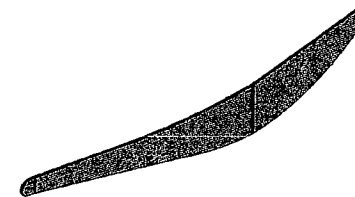
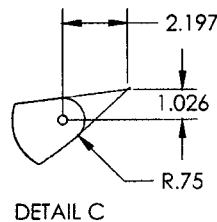
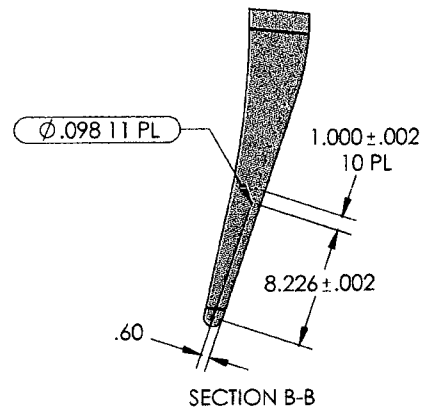
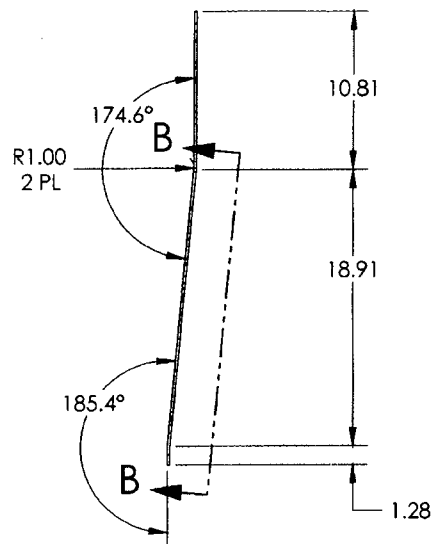
SHEET	07/02/16	647.1700	REV. C
SCALE	NONE		SHEET 1 OF 5

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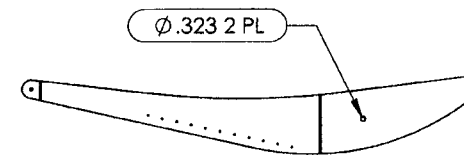


ORIGINAL DATE (MO DA YR) 06/05/09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY L. CARLINER	CHECKED BY J. BRAVO		
DRAWING APPROVAL J. BRAVO			
CONTRACT NO.		SKID DEFLECTOR ASSY	
LIMITS (OTHERWISE SPECIFIED)		SHEET	REV.
DIMENSIONS ARE IN INCHES		B	C
SURFACES ARE:		07M16	647.1700
3 PLACE DECIMALS ± .01		SCALE NONE	SHEET 2 OF 5
ANGLES ± .5°			

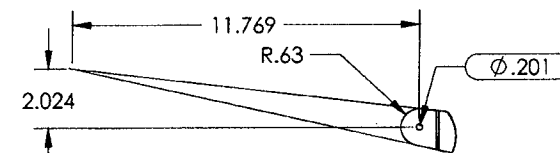
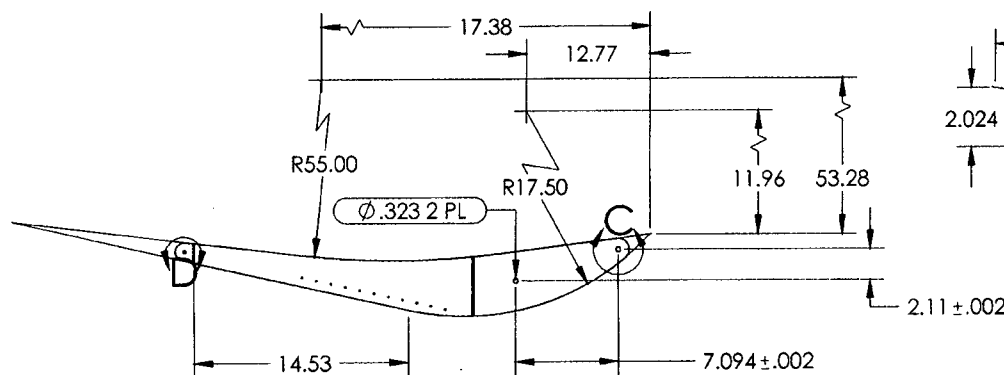
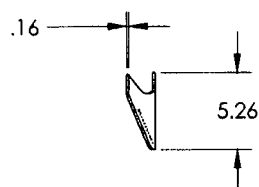
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647.1711 SHOWN
647.1710 OPPOSITE



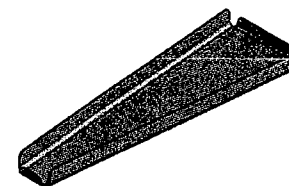
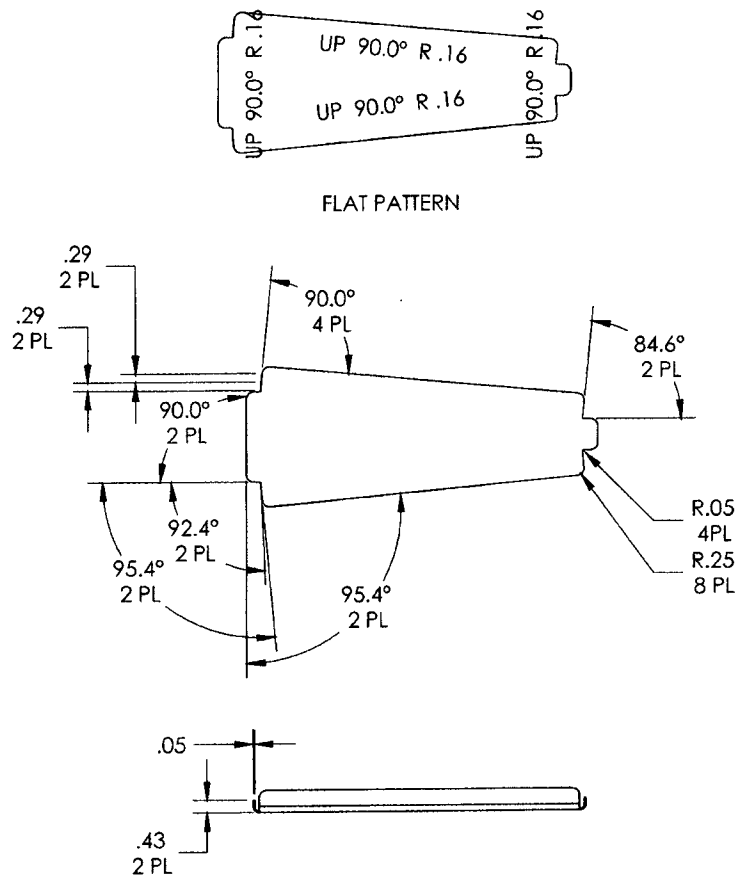
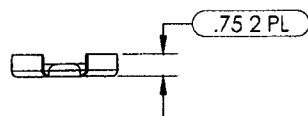
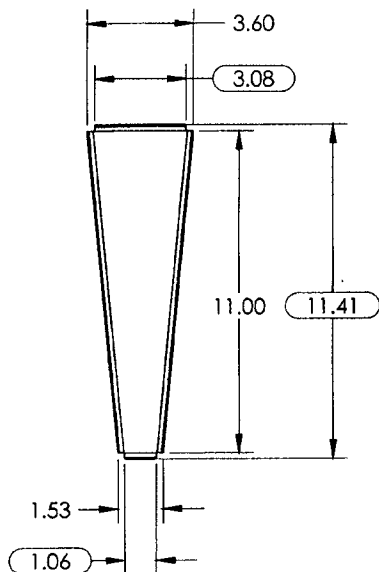
647.1714 SHOWN
647.1715 OPPOSITE



DETAIL D

ORIGINAL DATE 06/05/94		DESIGNED BY P. BRAVO		APICAL INDUSTRIES	
DRAWN BY P. BRAVO		CHECKED BY P. BRAVO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAVO		CONTRACT NO.		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES IN DECIMALS $\pm .01$ 1 PLACE IN DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SKID DEFLECTOR ASSY		REV. C	
MR. B	CAGE CODE 07M26	DATE 07/26/94	NO.	647.1700	REV. C
SCALE: NONE		SHEET 3 OF 5			

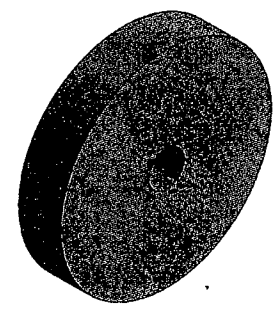
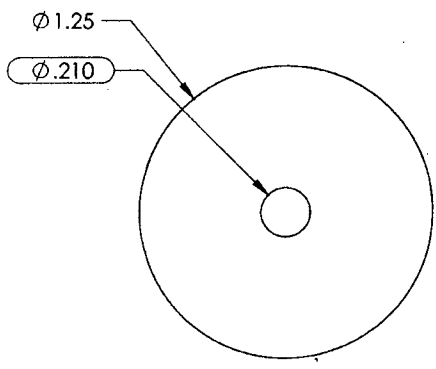
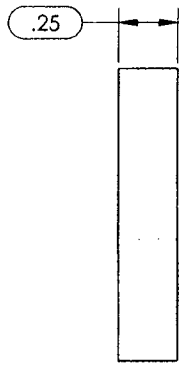
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647.1712

ORIGINAL DATE (MM-DD-YY) 08/05/09		APICAL INDUSTRIES	
DRAWN BY J. CARDEN P. BRAVO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		SKID DEFLECTOR ASSY	
CONTRACT NO.		DWG. NO. 647.1700	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES (FOR FRANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE NONE	REV. C
		SHEET 4 OF 5	

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647.1713

ORIGINAL DATE		APICAL INDUSTRIES	
INCHES (DIM. IN)		2608 TEMPLE HEIGHTS DR.	
DRAWN BY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
1. CANNON		P. BRAY	
DRAWING APPROVAL		SKID DEFLECTOR ASSY	
P. BRAY		SCALE NONE	
CONTRACT NO.		SHEET 5 OF 5	
UNLESS OTHERWISE SPECIFIED		REV. C	
DIMENSIONS ARE IN INCHES		647.1700	
TOLERANCES ARE:		07M26	
2 PLACE DECIMALS ±.01			
3 PLACE DECIMALS ±.005			
ANGLES ± .5°			

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 15.04.13	Job No.:	ADR Yes/No: N	ADR Date:	ECN #: 15- 555
Product No.: Apical 145-21, 350-61		Created By: KJ	Approved By: <i>[Signature]</i>	
Product Name: Cable Cutters		Checked By: <i>[Signature]</i>		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	SL/BG	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS/ED	
QC Coordinator	Y	PD	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/HS	15.04.13
Marketing	N	KO/SL	
Sales Support Manager	N	CP	

Reason for Change:
Revised hole dimensions, added delta notes 7-10 (647.1700), Revised dimensions of holes (650.9200)

Documents Affected:
Release 647.1700 Rev C2.(145-21) .
Release 650.9200 Rev NC1 (350-61)

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: _____

PAPERWORK UPDATE ☐ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	N			
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ	see below	15.04.13 <i>[Signature]</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify Airworthiness Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

Please update BOM per released drawing

W/O DONE to fix HOLE ON 647.1710 and 647.1711

ECN Verified & Complete: _____ Date: _____